

010202



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

C45-C

Job Sheet 195333



Part No: C45-C

Job Qty: 1 pcs

Part Name: Single Cage Assembly (C45 & C60 Hook)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/17/19

Job Tracking No:

Due Date: 5/27/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: C45-C rev.E IPP REV:A 18.01.22 NEW ISSUE DD VERF:DP IPP REV:B 19.05.02 AS PER DWG REV.E DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	External Load - Issue SN	1 pcs	5/27/19		0.00	1.00	External Load - 1		AP 2019/06/05
							External Load - 2		
							External Load - 3		
110	External Load - 2 - B4B	1 pcs	5/27/19		0.00	0.50	External Load - 1 - B4B		Maki 2019/6/5
							External Load - 2 - B4B		
							External Load - 3 - B4B		
120	QC 5	1 pcs	5/27/19		0.00	0.00	QC 5 - 10		DAS 30 JUN 9 6 2019
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
140	Packaging 3-1 - Stock - B4B	1 pcs	5/27/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S187998



Part: C45 - C

Job No: 195333

Serial No/Batch: S187998

Revision: E

Inspector:

Exp Date:

Instructions:

Date: 06/05/19

Plex 5/17/19 9:37 AM Dart.lajeunesse.marie

				Packaging 3 - 8 - B4B	DAS 30 JUN 06 2019
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - SA	1 pcs	5/27/19	0.00 0.00	QC 21 - SA - 21	DAS 27 JUN 06 2019
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - Issue S/N

Descriptions: 110 - (Small Fab)ASSEMBLE AS PER DWG ***HAND TIGHTEN ALL BOLTS, SPREAD COTTER PIN JUST ENOUGH SO THAT IT WILL NOT FALL OUT***

120 - (QC5- Inspect part completeness to step on W/O)

140 - (Identify as per dwg & Stock Location:_____)

160 - QC21- Final Inspection - Work Order Release)

Job BOM

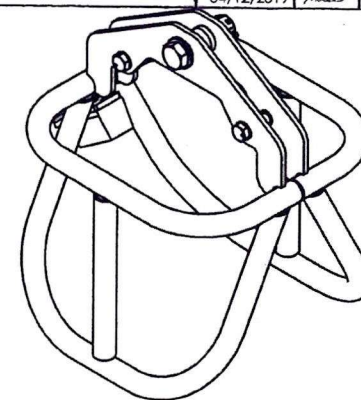
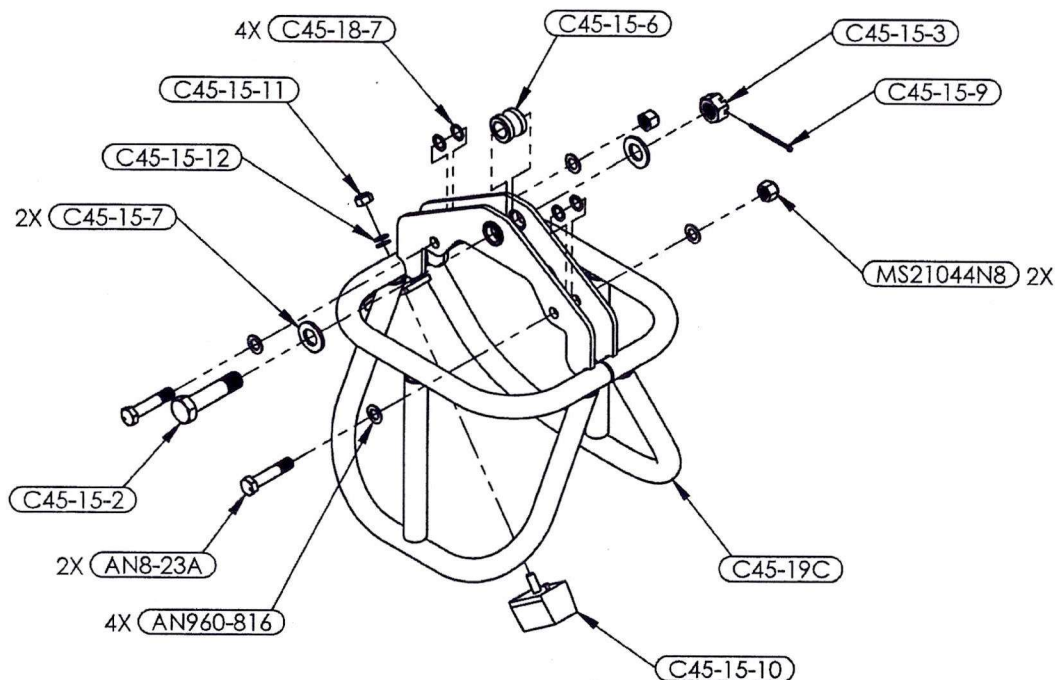
Part / Item	Component Name	Quantity	Operation	Container
AN12H32	Bolt	1 pcs (1 ea)	100-External Load - Issue SN	5159804
AN310-12	Castellated Nut	1 pcs (1 ea)	110-External Load - 2 - B4B	5004855
AN8-23A	Bolt	2 Ea (2 ea)	110-External Load - 2 - B4B	5085037
C45-15-10	Ford Bumper	1 pcs (1 ea)	110-External Load - 2 - B4B	5177794
C45-15-11	Nut, Cage Bumper	1 Ea (1 ea)	110-External Load - 2 - B4B	5036837
C45-15-6	Bushing, Lifting	1 pcs (1 ea)	110-External Load - 2 - B4B	5180462
C45-15-7	Washer, Lifting Bolt	4 pcs (4 ea)	110-External Load - 2 - B4B	5175984
C45-18-7	Shim	4 Ea (4 ea)	110-External Load - 2 - B4B	5184166
C45-19C	Weldment	1 pcs (1 ea)	110-External Load - 2 - B4B	5185501
MS21044N8	Nut, Self-Lock .500-20,UNJF-3B	2 Ea (2 ea)	110-External Load - 2 - B4B	5147503
MS24665-363	Cotter Pin	1 Ea (1 ea)	110-External Load - 2 - B4B	5092509-1
NAS1149C0663R	Washer	1 Ea (1 ea)	110-External Load - 2 - B4B	5076016-1
NAS1149F0832P	Washer	4 Ea (4 ea)	110-External Load - 2 - B4B	5076018-4

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-External Load - Issue SN	AN12H32	1	44	0
	AN310-12	1	26	0
110-External Load - 2 - B4B	AN8-23A	2	68	0
	C45-15-10	1	7	0
	C45-15-11	1	78	0
	C45-15-6	1	27	0
	C45-15-7	4	61	0
	C45-18-7	4	18	0
	C45-19C	1	2	0
	MS21044N8	2	37	0
	MS24665-363	1	79	0
	NAS1149C0663R	1	495	0
	NAS1149F0832P	4	235	0
Part Specifications				
Specifications could not be found.				

Plex 5/17/19 9:37 AM Dart.lajeunesse.marie

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3		AS DRAWN BY APICAL	11/6/2012	JAG	
4	15-0180	UPDATED TO NEW DRAFTING STANDARDS. CH'D P/N WAS C45-15-8 IS AN960-816. C45-15-4 DELETED, REPLACED WITH AN8-23A. C45-15-5 DELETED, REPLACED WITH MS21044N8. C45-18-7 ADDED TO BOM QTY 4.	7/22/2015	DPD	JAG
E	19-660	Replace B/O info for C45-15-2, C45-15-3 and C45-15-9, C45-15-12	04/12/2019	ML	ML



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 195333 ML
14-0517

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			C45-19C	1	WELDMENT		
			C45-15-2	1	LIFTING BOLT	STEEL	AN12H32
		B/O	C45-15-3	1	CASTLE NUT	STEEL	AN310-12
		B/O	C45-15-7	2	LIFTING BOLT WASHER	STEEL	3/4 (MCMMASTER-CARR #98023A036)
		B/O	C45-15-9	1	COTTER PIN	S.S	MS24665-363
			C45-15-10	1	FORD BUMPER		(#E3TZ-4730-A) MODIFIED
		B/O	C45-15-11	1	CAGE BUMPER NUT	STEEL	M10, CLASS 8 (MCMMASTER-CARR #90576A118)
		B/O	C45-15-12	1	CAGE BUMPER WASHER	STEEL	NAS1149C0663R
			C45-15-6	1	LIFTING BUSHING	4140/4142	
		B/O	C45-18-7	4	SHIM	STEEL	.025 X Ø.511 I.D. (MCMMASTER-CARR #3088A412)
		B/O	AN8-23A	2	BOLT	STEEL	1/2-20 X 1.47
		B/O	AN960-816	4	LIFTING BOLT WASHER	STEEL	AN960-816 (NAS1149F0863P)
		B/O	MS21044N8	2	NUT	STEEL	1/2-20

		TITLE	
		C45 CAGE	
DWG NO.		C45-C	REV E
MATERIAL		DRAWN BY: APICAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED: <i>ML</i>	
XXX ± .005		FRACTIONS ± 1/8	
XX ± .01		ANGLES ± 5°	
X ± .1		FINISH	
1. BREAK ALL SHARP EDGES .015 x 45°		SPEC	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON MODEL	
SCALE 1:8	DATE 4/12/2019	SHEET 1 OF 1	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS			
		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date :	Sequence #:	QTY Affected :			MRB (QSI042)
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
		Other/Details:			